

What Is Claimed Is:

1. A zipper strip for a reclosable bag or package, said zipper strip comprising:

5 a male interlocking profile, said male interlocking profile having a male interlocking member and a male web extruded therewith; and

10 a female interlocking profile, said female interlocking profile having a female interlocking member and a female web coextruded therewith, said male interlocking member being snappingly engagable within said female interlocking member to join said male and female interlocking profiles together,

15 wherein one of said male and female webs is wider than the other of said male and female webs in at least one of two directions from said male and female interlocking members, the greater width of the wider of said male and female webs being at least one flange extending widthwise beyond the other of said male and female webs,

20 so that said zipper strip may be attached to thermoplastic sheet material be sealing said at least one flange thereto without sealing said male and female webs to each other.

5 2. A zipper strip as claimed in claim 1 wherein one of said male and female webs is wider than the other of said male and female webs in only one of said two directions from said male and female interlocking members, the greater width of the wider of said male and female webs being a flange extending beyond the other of said male and female webs in said one of said two directions.

3. A zipper strip as claimed in claim 1 wherein one of said male and female webs is wider than the other of said male and female webs in both of said two directions from said male and female interlocking members, the greater width of the wider of said male and female webs being two flanges extending beyond the other of said male and female webs in opposite directions from said male and female interlocking members.

4. A method for attaching a zipper strip transversely on a sheet of thermoplastic sheet material during the production of plastic bags or packages having transverse zippers on a form-fill-and-seal machine, said sheet being advanced in amounts equal in length to that of the bags or packages being manufactured, a length of zipper strip being attached each time said sheet is brought to rest, said method comprising the steps of:

providing a zipper strip having interlocked male and female interlocking profiles, one of said male and female interlocking profiles having a web wider than that of the other on at least one of two lateral side thereof, the greater width of the wider web being at least one flange running therealong;

disposing a length of said zipper strip transversely upon said sheet of thermoplastic sheet material, said one of said male and female interlocking profiles having said wider web being in contact with said sheet and said at least one flange being oriented in the direction of the motion of said sheet; and

sealing said at least one flange onto said sheet of thermoplastic material without sealing said webs of

25 ~~said male and female interlocking profiles to each~~  
~~other.~~

5 5. A method as claimed in claim 4 wherein one of  
said male and female interlocking profiles has a web  
wider than that of the other on both of two lateral  
sides thereof, the greater width of the wider web  
being a flange running along each lateral side  
thereof.

5 6. A method as claimed in claim 4 wherein the step  
of disposing a length of said zipper strip  
transversely upon said sheet of thermoplastic sheet  
material is performed by a reciprocating shuttle  
having a clamp and a guillotine, said clamp being  
provided to pull said zipper strip from a supply  
transversely onto said sheet, and said guillotine  
being provided to cut said length of said zipper  
strip.

5 7. A method as claimed in claim 4 wherein the step  
of disposing a length of said zipper strip  
transversely upon said sheet of thermoplastic sheet  
material is performed by a pair of reciprocating  
clamps separated by a stationary guillotine, both of  
said reciprocating clamps grasping said zipper strip  
by said at least one flange thereof, one of said  
reciprocating clamps transferring said length of  
zipper strip cut by said guillotine onto said sheet of  
10 thermoplastic sheet material and holding said length  
during said sealing step, and the other of said  
reciprocating clamps pulling said zipper strip from a  
supply thereof toward said guillotine.

8. A method as claimed in claim 4 wherein the step of disposing a length of said zipper strip transversely upon said sheet of thermoplastic sheet material is performed by a vacuum conveyor means and  
5 a guillotine, said vacuum conveyor means pulling said zipper strip from a supply thereof and pulling lengths cut by said guillotine onto said sheet of thermoplastic sheet material.

9. A method as claimed in claim 4 wherein the motion of the sheet is incremental.

10. A method for manufacturing reclosable packages on a horizontal form-fill-and-seal machine, said method comprising the steps of:

providing a sheet of thermoplastic sheet material  
5 having at regular intervals therealong a length of zipper strip attached transversely across the center thereof and having strips without zipper strip along two lateral edges thereof, said zipper strip having interlocked male and female interlocking profiles, one  
10 of said male and female interlocking profiles having a web wider than that of the other on at least one of two lateral sides thereof, the greater width of the wider web being at least one flange running therealong, said one of said male and female  
15 interlocking profiles having said wider web being attached to said sheet, said at least one flange being oriented in a direction of motion of said sheet on said horizontal form-fill-and-seal machine, said at least one flange being sealed to said sheet to attach  
20 said interlocked male and female interlocking profiles thereto;

providing a product conveyor to deposit a product to be packaged onto said sheet of thermoplastic sheet material;

25        folding said two lateral edges of said sheet of thermoplastic sheet material toward one another and around said product;

         sealing said two lateral edges of said sheet to one another to form a tube therefrom enclosing said  
30        product;

         sealing said tube transversely to each said length of zipper strip without sealing said webs of said male and female interlocking profiles to each other; and

35        cutting said sealed tube to separate each completed package from the next.

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